



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4881-042
Job Sheet 185014



Part No: D4881-042

Job Qty: 1 ea

Part Name: 206A/B AFT Leg Assembly, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/20/18

Job Tracking No:

Due Date: 10/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 3,4 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP REV:B 14.07.07 AS PER
DWG REV.C DD VERF:JLM IPP REV:C 18.01.29 LASER ENGRAVE NOW MADE IN HOUSE DD VERF:JFS

Ship Via:

6708

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/31/18	10/31/18	0.00	0.00	Start Up Small Fab-4		NOV 27 2018 6
110	Small Fab	1 pcs	10/31/18	10/31/18	0.00	0.78	Small Fab-8		5015 9-89
120	QC	1 pcs	10/31/18	10/31/18	0.00	0.00	QC5		38
130	Small Fab	1 pcs	10/31/18	10/31/18	0.00	0.78	Small Fab-8		5015 9-89
140	QC	1 pcs	10/31/18	10/31/18	0.00	0.00	QC5		DAS 38
180	Packaging	1 pcs	10/31/18	10/31/18	0.00	0.00	Packaging3-2		46 NOV 28 2018
190	QC21-SA	1 Ea	10/31/18	10/31/18	0.00	0.00	QC21		9-89 DAS NOV 28 2018

Part Op 110 - ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-2 AND D4885-3. DRILL OUT EACH HOLES
Descriptions: USING A PILOTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9974
AS PER DWG.

130 - 1- INSTALL PIN/COLLAR AND END FITTING WITH HYSOL OR MAGNOBOND 6398 WHILE STILL WET AS PER
DWG USE DT9974 A/R BATCH: 5080785 2- LASER ENGRAVE ASSEMBLY PART#, S/N AS PER DWG
QSI 44 6.8

200 01/2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4881-1	Strut	1 Ea (1 ea)	90-Start up Operation	5118469
D4885-2	End Fitting	1 Ea (1 ea)	90-Start up Operation	6124006
D4885-3	End Fitting	1 Ea (1 ea)	90-Start up Operation	5120578
HL32PB5-12	Hi-Lok Pin	4 Ea (4 ea)	90-Start up Operation	5118777
HL86-5	Hi-Lok Collar	4 pcs (4 ea)	90-Start up Operation	5108576

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4881-1	1	24	0
	D4885-2	1	5	0
	D4885-3	1	2	0
	HL32PB5-12	4	172	0
	HL86-5	4	152	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																	
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DART AEROSPACE
 Container No: S131805
 Part: D4881 - 042
 Job No: 185014
 Serial No/Batch: S131805
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: Various STC's
 Date: 11/27/19

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 CANADA
 Tel: 1 813 632-5200
 Email: sales@dartero.com
 www.dartaerospace.com

Specifications could not be found.

Plex 10/22/18 8:21 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
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